Date:

Tuesday, 04/07/2006 12:35:21 PM

Linda Lacelle .User:

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Job Number** : 27736

**Estimate Number** 

e,

: 11231

P.O. Number

AIU:

: 04/07/2006 This Issue Prsht Rev.

: NC

: 28/06/2006

S.O. No. : 1/1/2

Type

: MACHINED PARTS

**Drawing Revision** Material

**Drawing Name** 

**Part Number** 

**Drawing Number** 

**Project Number** 

: 22/07/2006 **Due Date** 

: WEAR PLATE

. D2348 REV B2

: D2348

: N/A

Qty:

50 Um:

Each

Checked & Approved By

Comment

First Issue

Written By

Previous Run

: Est Rev A

Removed from 9 Digit 05-12-05 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 .063 Sheet

M6061T6S063 1.0

Comment: Qty.: 0.0208 sf(s)/Unit Total: 1.0395 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063)

Batch: 1/1855 2.0

Comment: FLOW WATER

3.0 OC2

INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD



6.0 QC5

Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP



Tuesday, 04/07/2006 12:35:21 PM 'Date: Linda Lacelle User: **Process Sheet** Drawing Name: WEAR PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2348 Job Number: 27736 Job Number: Seq. #: Description: **Machine Or Operation: OUTSIDE SERVICE** OUTSIDE SERVICES 7.0 Comment: Sub-Contracting PURCHASING C206/08/09 Issue P/O: 1197 Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached 8.0 PACKAGING RESOURCE #1 **Comment: PACKAGING RESOURCE #1** Receive & Inspect For Transit Damage Ensure certificate of conformity is attached INSPECT POWDER COATICHEMICAL CONVERSION 9.0 Comment: INSPE POWDER COAT/CHEMICAL CONVERSION 10.0 FE832EF PEM Insert Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s) Pick: Qty Part Number Description Batch M101483 4 FE832EF PEM Insert\_\_\_ M10163\$ SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Insert as per Dwg D2348 12.0 QC5 **Comment: INSPECT** WORK TO CURRENT STEP PACKAGING RESOURCE #1 13.0 PACKAGING 1 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: 3T40

Date:

Tuesday, 04/07/2006 12:35:21 PM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: WEAR PLATE** 

Job Number: 27736

Part Number: D2348

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

14.0

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



A06.08.29 U06.08.23

9.1 Perm. Change. 66.08.28 E

Wednesday, 6/28/2006 4:17:20 PM User: Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : WEAR PLATE Job Number : 27736 : 11231 **Estimate Number** : D2348 Part Number P.O. Number D2348 REV B2 This Issue : 6/28/2006 S.O. No. : **Drawing Number** : NC **Project Number** : N/A Prsht Rev. : MACHINED PARTS : // : A First Issue Type **Drawing Revision** Material **Previous Run Due Date** : 7/22/2006 Qty: Written By **Checked & Approved By** Removed from 9 Digit 05-12-05 JLM Comment **Additional Product** Job Number: Seq. #: **Machine Or Operation: Description:** M6061T6S063 6061-T6 .063 Sheet 1.0 Comment: Qty.: 0.0208 sf(s)/Unit Total: 1.0395 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Batch: M18556 SHEAR 2.0 Comment: SH **⊄**ut blan HAAS CNC VERTICAL MACHINING #1 3.0 VERTICAL MACHINING #1

Each

50 Um:

QC2 4.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



5.0

QC8

Comment: SECOND CHECK

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				

NCR:	See r	Der 080 WC	ORK OR	DER NON-CONFORMANCE	(NCR)	ARC		
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	<b>Initial</b> Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
06/08/17	7	46 part came back From Blads anodize 4 part were missing	A.	Design Mgr  Qty 46. Cantract Sub-contractor to inform them of missing Parts.  NO Si	06.08.75 esponse	<i>b</i>	4/4	

Part No: Da348	PAR #:	NA.	Fault Category:	Supplia	NCR: (	Yes No	DQA: _	M	Date: 66.08.2	4
NOTE: Date & initial all entries		,				QA: N/C C	losed: /	1-	Ob.08.24 Date:	

Wednesday, 6/28/2006 4:17:20 PM . Date: User: Kim Johnston **Process Sheet Drawing Name: WEAR PLATE** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27736 Part Number: D2348 Job Number: Seq. #: Machine Or Operation: **Description:** SMALL & MEDIUM FAB RESOURCE 1 6.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP OUTSIDE SERVICE **OUTSIDE SERVICES** 8.0 Comment: Sub-Contracting PURCHASING Issue P/O: Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 FE832EF PEM Insert Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s) Pick: Qty Part Number Description Batch 4 FE832EF PEM Insert 12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Insert as per Dwg D2348

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification					
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector			
	į.										

Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date: _		
NOTE: Date & initial all entries				QA: N/C C	losed:	Date: _	·	· · · · · · · · · · · · · · · · · · ·

, Date:

Wednesday, 6/28/2006 4:17:20 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 27736

7736

Part Number: D2348

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

13.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

14.0

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:\_

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



## Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Date Qty	Approval Mfg / Design Mgr	Approval QC Inspector					
			j									

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	A	Approval			
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	QC Inspector			
				•							
						-					
								:			

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	<u>~</u>
NOTE: Date & initial all entries				QA: N	I/C C	osed:	Date:	

DART AEROSPACE LTD	Work Order:	21736
Description: Wear Plate	Part Number:	D2348
Inspection Dwg: D2348 Rev: B2		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	ele 🗌	Proto	otype	
Drawing	Tolerance	Actual	Accept	Reject	Method of	Co
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	

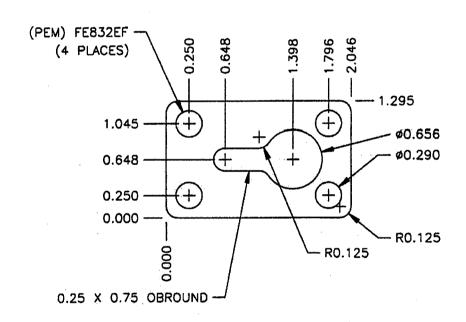
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010				-	
0.648	+/-0.010					
1.796	+/-0.010					
2.046	+/-0.010					
1.295	+/-0.010					
0.656	+0.005/-0.000					
0.290	+0.005/-0.000				_	
0.250	+/-0.010					
0.250	+/-0.010	(				
0.648	+/-0.010	1				
1.045	+/-0.010	y	XXO	X		
			N N	99		
			4		•	

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

A 04.06.25 New Issue P/O D350-616-015 KJ/JLM	Rev	Date	Change		Revised by	Approyed
7,7 = 1.0 · · · · · · · · · · · · · · · · · · ·	Α	04.06.25	New Issue	P/O D350-616-015		<i>S</i> []



DESIGN DRAWN BY  B WILLIAMS B WILLIAMS			DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHI	ECKED		APPROVED	DRAWING NO.	REV. 8
D	りん	Š	D	D2348 SHEET	1 OF 1
DAT	Ε		7	TITLE	SCALE
95	:01:2	0		WEAR PLATE	1:1
В			95:02:20	CHANGED PEM INSERT TO 8-32	
Bi			00.03.07	CHANGE TO AISI 304/316 MATERIAL	
32	2 -#	一件	02.02.21	CHANGE BACK TO 6061-Tb	



NOTES: 1) MATERIAL: 6061-TO ALUMINIM SHEET 0.063 THICK FER QQ-A-250/11 (M6061T65)

2) FINISH: BLACK AMODIZE PER MIL-A-862SF TYPE I / TB/TC/T/TB CLASS 2

SHOP COPY

3) INSMLL FERSZ EF INSERTS AFTER AMODIENG

RETURN TO

4) ALL DIMENSIONS ARE IN INCHES

ENGINEERING

TOLERANCES ARE PER PART OST OIB UNLESS OTHERWISE NOTED.

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK AFTER-ANODIZING INSTALL (PEM FE832EF) 4 PLACES

DART AEROSPACE LTD	Work Order:	27736
4		
Description:	Part Number:	2348
Inspection Dwa: Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$0.656	+1-0.0050.00	0.656	1		verN	
	H-0.0050001		J		VRIN	
2.046	+1-0.010	2.050	<b>V</b>		VRIN	
1.295	+1-0.010	1.298	<b>√</b>		Very	
0.648	+1-0.010	0.648	√		Nory	
0.250	+1-0.010	0.250	<b>V</b>		ver N	
1.796	+1-0.010	1.799	V		NELY	
1.045	+1-0.010	1.045			vern	
						·
	·					
				, ,		

	1 1					
Measured by:	M MI	Audited by:		Prototype Approval:		<u>ام</u>
Date:		Date:	06-07-20	Date:	10	117

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

#### TNM

### ANODISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation,Pointe Claire QC H9R 4Z2 Telephone: (514) 429-7777 Fax: (514) 429-5108 Certifié ISO 9001-2000 / AS9100 certified approuvé NADCAP approved

49229

14-Aug-2006

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

PURCHASE ORDER/ NO. DE COMMANDE:

00001797



TEM: COMMANDE ORDERED	EXPEDIE - PART NUMB SHIPPED	ER & DESCRIPTION	PART PROCESS & IF	EATMENT.
1 50	50 D2348	WEARPLATE		R MIL-A-8625F TYPE ILCLASS 2 ALL
	-		OVER	

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées. Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications. Travel cards have been filed and are available for viewing upon request.

Signature/Signed:\_

□Directeur de la Qualité / QA. Manager 🗆 🗆 🗀